



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5642-1

Job Sheet 197941



Part No: D5642-1

Job Qty: 18 pcs

Part Name: Saddle Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 8/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: D5642 REV.A IPP REV:A 19.01.15 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	18 pcs		8/2/19	0.17	0.90	Waterjet - Flow		2/19/09/03
110	QC 2	18 pcs		8/2/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		2/19/09/03
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
120	QC 8	18	8/2/19	0.00 0.00	QC 8 - 12	
		pcs			QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
130	Handfinish - 1-1 Chemical-B4B	18	8/2/19	0.00 0.72	Handfinish - 1 - 1 - B4B	
		pcs			Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	

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9-69

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SEP 04 2019

				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140	QC 7	18	8/2/19	0.00 0.00	QC 7 - 10
		pcs			QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
					QC 7 - 61
					QC 7 - 81
150	Packaging 3-1 - Stock - B4B	18	8/2/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B

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PC GA-TRD

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	18 pcs	8/2/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 SEP 04 2019
				QC 21 - SA - 53	9-09
Part Op 100 - 1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Chemical Conversion Coat per QSI005 4.1) 140 - (QC7-Inspect Chemical Conversion Coat) 150 - (Identify as per dwg & Stock Location: _____) 160 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6S.080	6061-T6 .080 Sheet	.7200 sf (.04 ea)	100-Waterjet - Flow - 1	S200297	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M6061T6S.080	1	284	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order:	19794
Description: Saddle Spacer		Part Number:	D5642-1
Inspection Dwg: D5642-1	Rev: 1	Page 1 of 1	

INSPECTION SHEET

Measured by:	<i>an</i>	Checked by:	<i>40</i> <i>9-89</i>	QC Inspector:	
Date:	<i>19/09/03</i>	Date:	<i>SEP 03 2019</i>	Date:	

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	Date : _____ Sequence #: _____ QTY Affected : _____ Description Work Order Deviation 	MRB (QS1042) ☐ Disposition 	Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																																																			
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">Operator</td> <td style="width:33%;">☐</td> <td style="width:33%;"></td> </tr> <tr> <td>Manufacturing Process</td> <td>☐</td> <td></td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td></td> </tr> <tr> <td>Handling/Preservation</td> <td>☐</td> <td></td> </tr> <tr> <td>Material</td> <td>☐</td> <td></td> </tr> <tr> <td>Product Improvement</td> <td>☐</td> <td></td> </tr> <tr> <td>Process Improvement</td> <td>☐</td> <td></td> </tr> <tr> <td>Human Factors</td> <td>☐</td> <td></td> </tr> </table>		Operator	☐		Manufacturing Process	☐		Equip/Tooling	☐		Handling/Preservation	☐		Material	☐		Product Improvement	☐		Process Improvement	☐		Human Factors	☐		FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">Pressure/Forced</td> <td style="width:33%;">☐</td> <td style="width:33%;"></td> </tr> <tr> <td>Bending</td> <td>☐</td> <td></td> </tr> <tr> <td>Crushing</td> <td>☐</td> <td></td> </tr> <tr> <td>Cracks</td> <td>☐</td> <td></td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>☐</td> <td></td> </tr> <tr> <td>Marks/Chatter</td> <td>☐</td> <td></td> </tr> <tr> <td>Mislabeled</td> <td>☐</td> <td></td> </tr> <tr> <td colspan="3">Other/Details: _____</td> </tr> </table>				Pressure/Forced	☐		Bending	☐		Crushing	☐		Cracks	☐		Crimp/Kink/Ripple/Wave/Twist	☐		Marks/Chatter	☐		Mislabeled	☐		Other/Details: _____			Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐
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